Work Orde Friday, May 14,												Page 1
Revision ID:	D3536-13 Gasket		/	Accept				Setup	Start Stop			
Start Date: Required Date: Reference:	5/14/2010 5/20/2010	Start Qty: 12.00 Req'd Qty: 12.00) 1807 1814 1814 1814 1814 1807 1816 1816 1816		Cust Item I Customer:	D:				•		
Approvals:	Process Plan QC:	:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop		
Sequence ID/ Work Center ID		Operation Description	,	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr D3536	Revis	sion Nbr			•					<u>_</u>		
100 		FLOW WATER JET Memo 1-Cut as per Deburr if nec		0.00 , 0.00 □Prog Rev:_	A			BIG)-5-	- 90		

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QC2- Inspect parts off machine FAI/FAIB

0.00

Quality Control

Memo

0.00

1310-5-20

QC8- Inspect parts - second check

Memo

Swortzi

0.00

Quality Control

W/O:			WO	RK ORDER CHANG	GES		`		
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cated	orv:	NCR: Yes	No DO	Δ.	Date:	
Resolution:									
NCR:			· · · · · · · · · · · · · · · · · · ·	R NON-CONFORM					
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	O 	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sect	ion C	Chief Eng	QC Inspector
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				•					

Item ID:

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D3536-13

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 5/20/2010

Gasket

5/14/2010

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Process Plan:

Date:

Tooling:

Date:

Start Run

Reject

Qty



Date:

SPC (Y/N):

Set Up/

Date:

Draw

Rev.

Plan

Code

Stop



Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Memo

Run Hours

0.00

0.00

Draw

Number

Reject Insp. Stamp Number

Accept

Qty

140

QC21- Final Inspection - Work Order Release

0.00



Quality Control

Memo

0.00

Dart Aerospa	ce Ltd	
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W/O: WORK ORDER CHANGES												
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	Re	esolution:					Date: _					
NCR:	_		WORK ORD	ER NON-CONFORM	ANCE (NCR)						
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Description Chief Eng	tion B Sign & Date			Approval QC Inspector				
		,										
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Picklist Print

Friday, May 14, 2010 11:51:33 AM

Work Order ID: 58684

Parent Item: D3536-13

Gasket Parent Item Name:

Comments: IPP Rev:A

New Issue 07-02-14 JLM

Start Date: 5/14/2010

Required Date: 5/20/2010

Page 1

Start Qty: 12.00

Required Qty: 12.00

1810-5-20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MNEO60\$.063		Purchased	No			100	sf	139.2531	0.8269	10.		
											1810-5-2	6



NEOPRENE SHEET 0.063

Location MAT052

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Loc Qty

Loc Code

139.2531 139.2531

114691

W/O:	O: WORK ORDER CHANGES												
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NCR:		V	WORK ORE	DER NON-CONFO	RMANCE	(NCR)							
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DART AEROSPACE LTD	Work Order:	58684
Description: Gasket	Part Number:	D3536-13
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	37.90	v			
29.40	+/-0.030	39.40	¥			
27.40	+/-0.030	37.40	N.			
23.90	+/-0.030	23.90	&			··-
18.98	+/-0.030	18.98	کلا			
14.07	+/-0.030	14,07	X			
9.15	+/-0.030	9.15	25			
5.65	+/-0.030	5,65	7			
3.90	+/-0.030	3,90	4			
8.00	+/-0.030	8.00	7			
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Measured by:	B	Audited by:	8	Prototype Approval:	N/A
Date:	10-2-20	Date:	10(15/2)	Date:	N/A

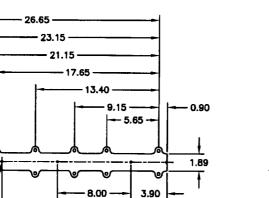
Rev	Date	Change	Revise	d by.	Approved
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06.10.25 NEW ISSUE	06.10.25	A	
GASKET 1:10		06.10.25	
TITLE		DATE	
D3536 SHEET 1 OF 6		¥	
DRAWING NO. REV. A	APPROVED , //	CHECKED	
DART AEROSPACE USA, INC.	CB	CB CB	

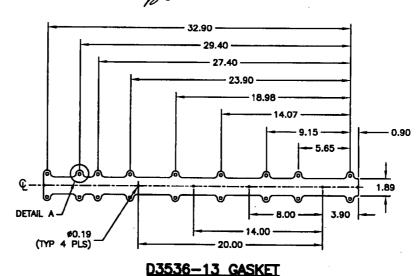


D3536-11 GASKET

14.00

SHOP COTY **RETURN TO ENGINEERING** UNCONTROLL BLACOP SUBJECT TO AMENDME... WITHOUT NOTICE WORK ORDER NO. <u>58684</u>

B10-5-14



DETAIL A

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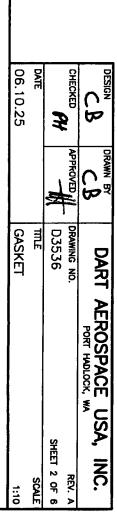
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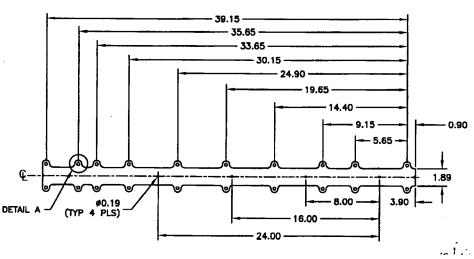
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.083)

- PART IS SYMMETRICAL ABOUT &
 TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

Dart .	Aeros	pace	Ltd
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D3536-15 GASKET

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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM
- PART IS SYMMETRICAL ABOUT ©
 TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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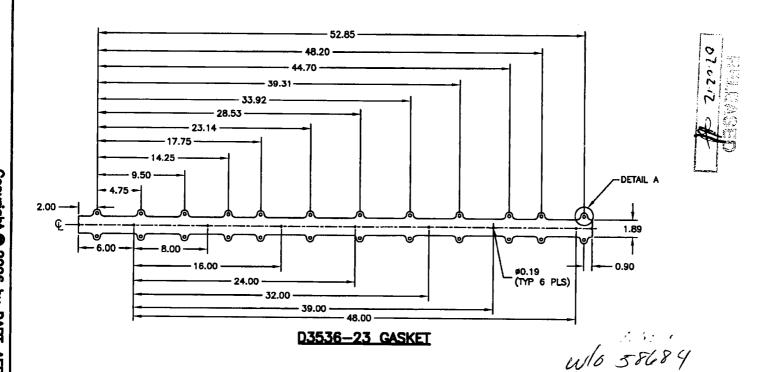
CHECKED DATE 06.10.25 B 3 DRAWING NO. GASKET DART AEROSPACE PORT HADLOCK,

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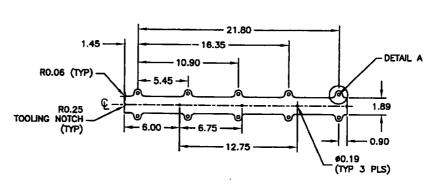
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2) FINISH: NONE

3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

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D3536-25 GASKET

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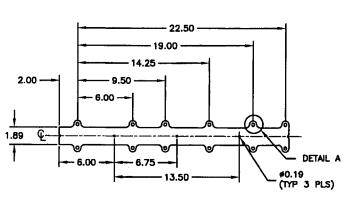
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- DUROMETER (REF DART SPEC. M-NEO6O-S

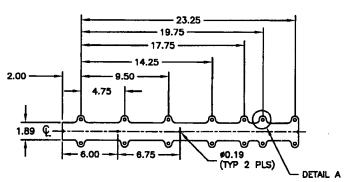
 2) FINISH: NONE

 3) PART IS SYMMETRICAL ABOUT ©

 4) TOLERANCES ARE PER DART QSI 018 UNLESS
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 5) ALL DIMENSIONS ARE IN INCHES

 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
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- 7) SEE PAGE 6 FOR DETAILS AND SECTION



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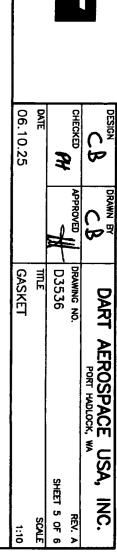
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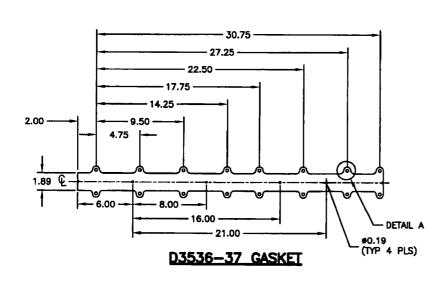
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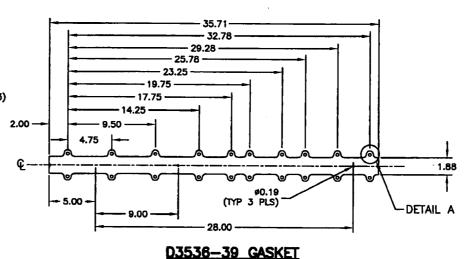




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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
 IDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



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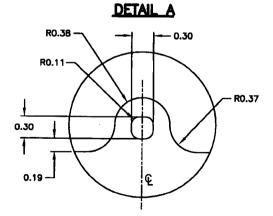
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE 3) PART IS SYMMI

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- PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



W/O:		WORK ORDER CHANGES										
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